

Work Order ID 110934-1

January-08-14 12:41:17 PM

110934

Page 1

Item ID: D4776-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Basket Strut Clevis

Stop

NS2

Start Date: 1/08/14

Start Qty: 30.00

30

Cust Item ID:

Required Date: 1/08/14

Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: M L J

Date: 14-01-09

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4776

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FB167

Rev: N/A &

Dwg D4776 Rev: C

2-Deburr per dwg D4776

SA

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SA

DAS
40
8-83

14/01/21

100-100-1
100-100-2

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Item ID: D4776-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Basket Strut Clevis
 Start Date: 1/08/14 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 1/08/14 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
111 *111* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		DA 14/01/21		6	φ		DAS 08 9-89
112 *112* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6		76 14-1-22	
113 *113* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				6	φ	14-1-23	DAS 34 9-89

1870

1870

1870

1870

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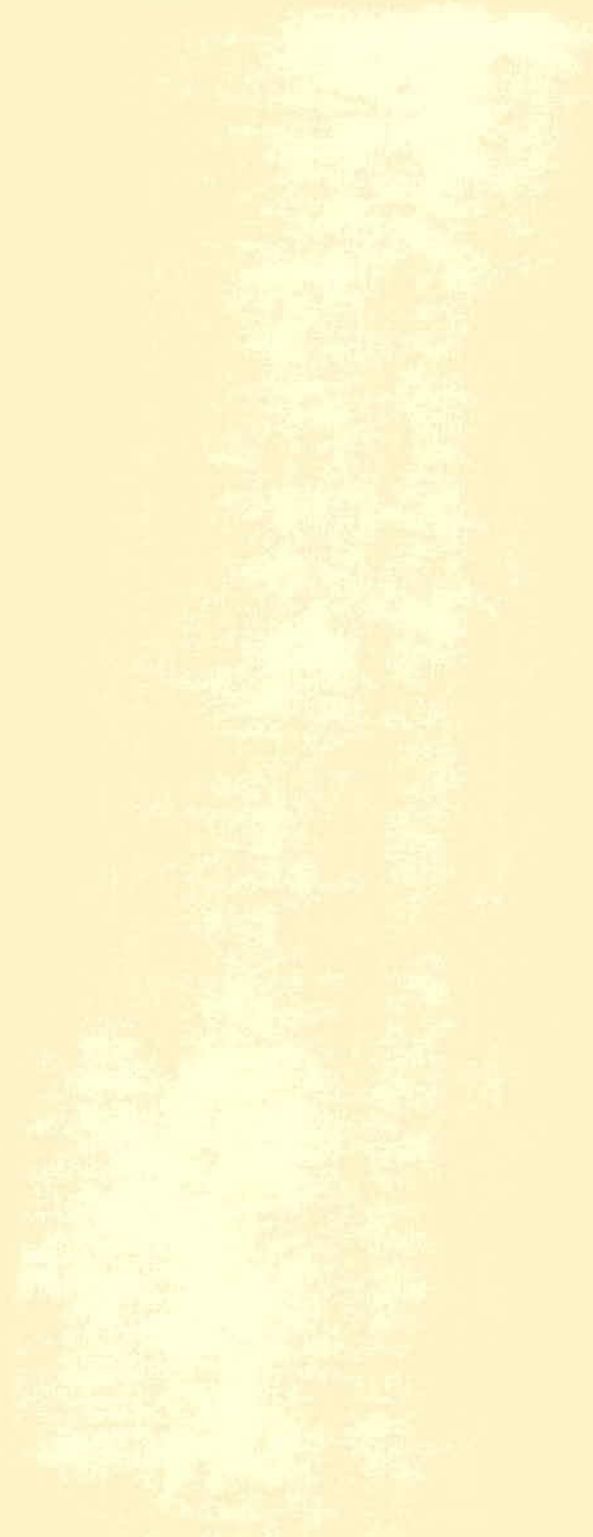
Page 3

January-08-14 12:41:17 PM

Item ID: D4776-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Basket Strut Clevis
 Start Date: 1/08/14 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 1/08/14 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115 *115* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M126829</i> Memo MASK .403 ROUND SECTION <i>START: 7:15</i> <i>OCENT: 8:20</i> <i>FINISH: 7:45</i>	0.00				6	6	14-1-23	DAS 34 9-89
116 *116* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				6			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <i>51123</i> Memo	0.00 0.00				6x	28	14-01-23	DAS 9-89



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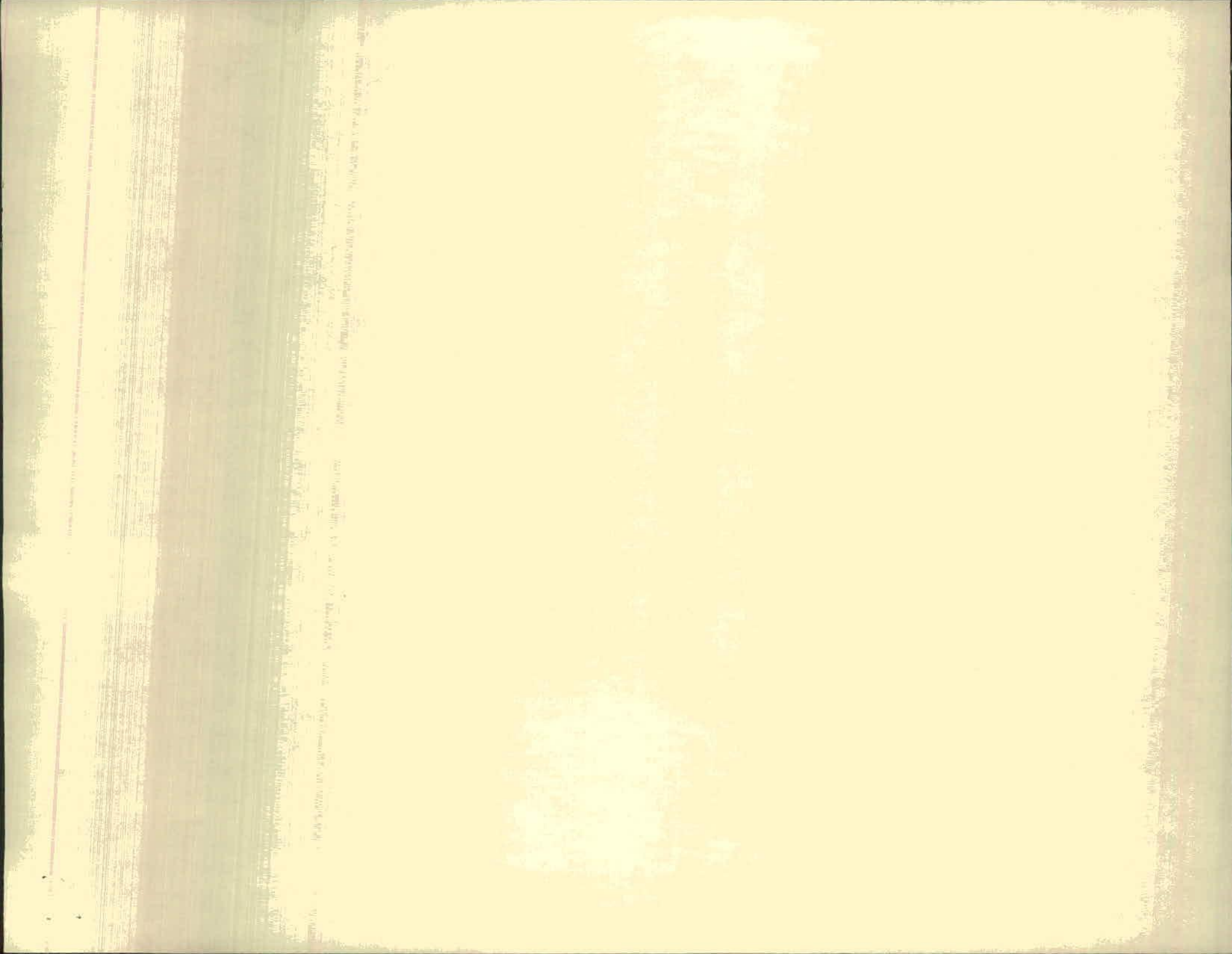
Item ID: D4776-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Basket Strut Clevis
Start Date: 1/08/14 Start Qty: 30.00 *30* Cust Item ID:
Required Date: 1/08/14 Req'd Qty: 30.00 *30* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 14-01-23

④ 14-01-24



Picklist Print

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Page 1

Work Order ID: 110934

Parent Item: D4776-1

Start Date: 1/08/14

Required Date: 1/08/14

Parent Item Name: Basket Strut Clevis

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS
REV.B DD VERF:JLM

IPP REV:B 13.09.26 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.500 6061-T6 Round Bar 1.50		Purchased	No			100	f	17.0000	0.29	9.157896		SA 14-1-20	

Location

Loc Qty

Loc Code

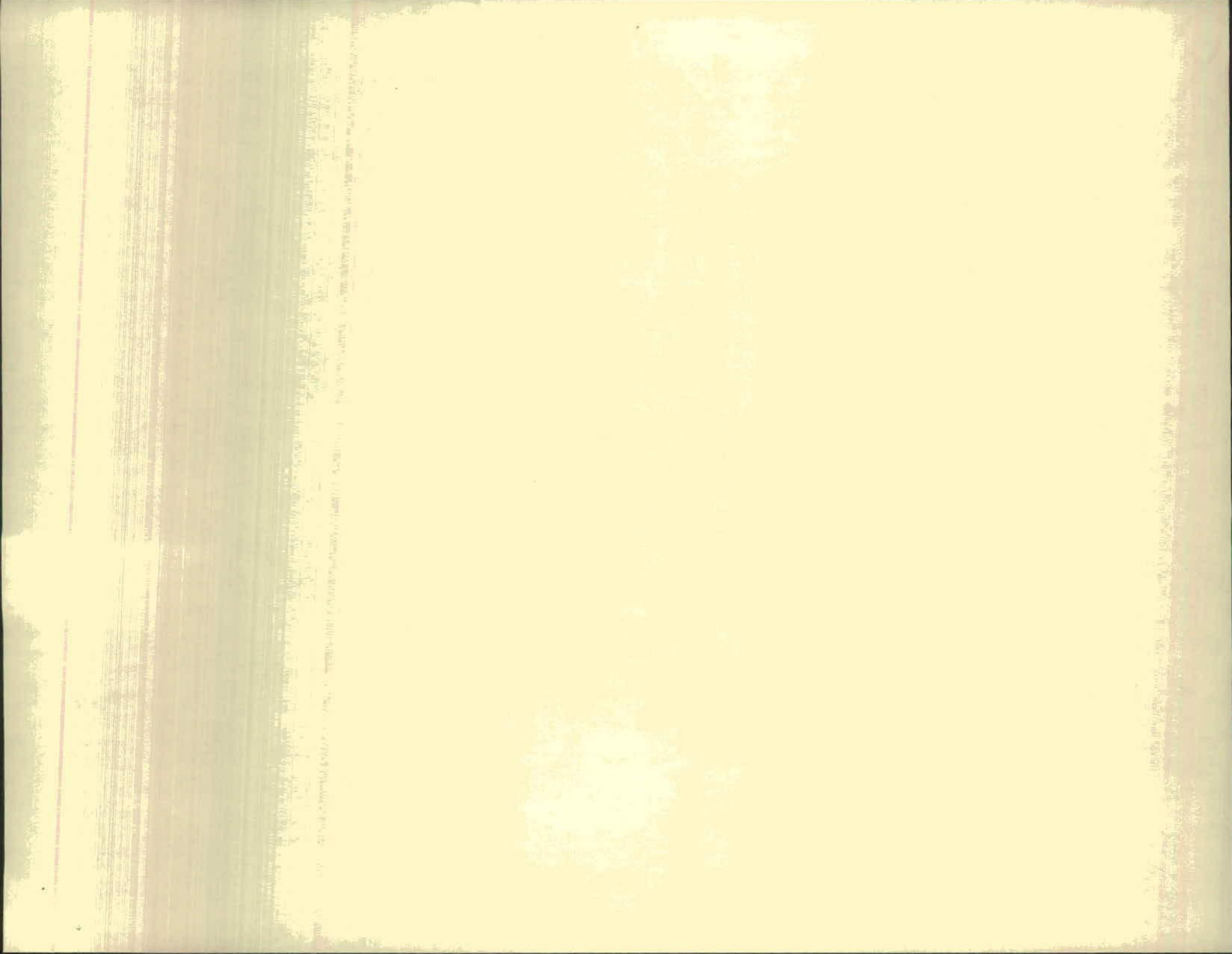
MAT013

17

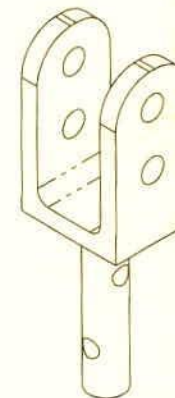
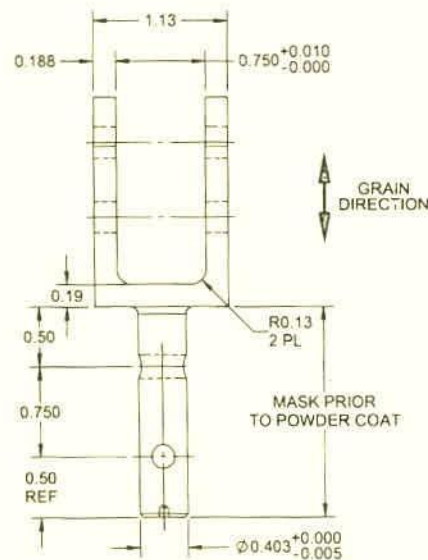
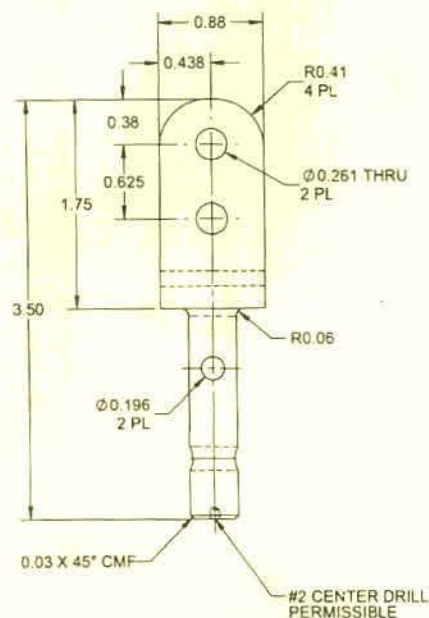
→ m127464

17

10.0



110934
MLJ
14-01-09



D4776-1 BASKET STRUT CLEVIS

RELEASED
14-01-09

NOTES:

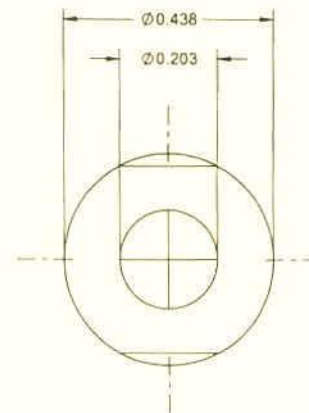
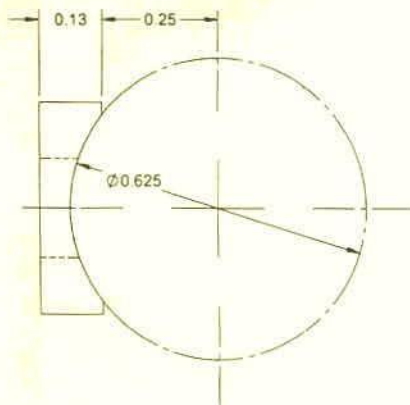
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

C	SHT 2, C7, 1.13 DIM WAS 0.88, C8 0.588 WAS 0.438, ADDED TOP VIEW WITH CHAMFERS, REASON: INTERFERENCE	AJS	13.10.31
B	MULTIPLE DIMENSIONS UPDATED ON -1 FOR INSTALLATION OF 1/4" FASTENERS, INDEX OF HOLES ON THE STEM OF -1 ROTATED 90°, FINISH ADDED TO -1 TOLERANCE ON CLEVIS FOR -1 & -3 TIGHTENED ADDED -5, REASON: EASE OF INSTALLATION C3-2 DEPTH DIM ADDED	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AL	DRAWING NO.	REV. C
MFG. APPR.	DEF	D4776	SHEET 1 OF 3
APPROVED	MLJ	TITLE	SCALE
DE APPR.	MLJ	BASKET STRUT MACHINED PARTS	NTS
DATE	13.10.31	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4776 TITLE BASKET STRUT MACHINED PARTS COPYRIGHT © 2013 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED UNDER EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT PERMISSION WITHOUT</small>	REV. C
DRAWN	AJS		SHEET 2 OF 3
CHECKED	<i>AJS</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	13.10.31		

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D4776-5 SPACER



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4776-5" AND B/N PER QSI 044 METHOD 6.7
- 7) WEIGHT: LESS THAN 0.01 lbs

13 2014-01-03

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG APPR	<i>[Signature]</i>	D4776	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET STRUT MACHINED PARTS	NTS
DATE	13.10.31	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

